



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SWA3-200
Job Sheet 181735



Part No: SWA3-200

Job Qty: 10 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/7/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-200 Rev 12 IPP Rev A 18.02.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	8/10/18	8/10/18	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	8/10/18	8/10/18	0.00	10.00	MORI SL2500Y		
120	QC	10 pcs	8/10/18	8/10/18	0.00	0.00	QC2		
130	QC	10 pcs	8/10/18	8/10/18	0.00	0.00	QC8		
140	Packaging	10 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea	8/10/18	8/10/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks to 4.375".

Descriptions: 110 - 1-Machine as per DWG.FB 301 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	3.6000 ft (.36 ea)	90-Start up Operation	5100150

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R1.500	4	4	0

Part Specifications

Specifications could not be found.

Flex 8/7/18 1:35 PM Dart.lajeunesse.marie

GA-AIAIN

33"



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CANADA
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Container No: S100151



Part: SWA3-200

Job No: 181735

Serial No/Batch: S100151

Revision: 12

Inspector:

Exp Date:

Instructions:

Date: 08/08/18

RT AEROSPACE LTD

Work Order:

181738

Description: Lower End

Part Number:

SWA3-200

Inspection Dwg: SWA3-200

Rev: 12

Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	$\pm .01$	4.197			Vern LPO9	
.38	$\pm .01$	.375				
45°	$\pm .5$	45°				
1.95	$\pm .01$	1.960				
Ø.750	$\pm .010 / -.000$	.760				
.50	$\pm .01$	.50				
Ø1.066	$\pm .000 / -.003$	1.0646			Opt Comp	
.81	$\pm .01$	.812			Mich LPO6	
Ø.640	$\pm .01 / -.00$	.644			Mich LPO4	
R.07	$\pm .01$	.062			Rad gage	
Ø.75	$\pm .01$	.760			Vern LPO9	
.03 x 45°	$\pm .01 \times .5°$	.032 x 45°				
Ø1.50	$\pm .01$	1.492				
R.188	$\pm .005$	.188			Rad gage	
.27	$\pm .01$	.271			Vern LPO9	
.02 x 45°	$\pm .01 \times .5°$	.03 x 45°				
.75	$\pm .00 / -.02$	.740				
1.75	$\pm .01$	1.750				
Ø.438 x .65	$\pm .005 \times .01$	.439 x .65				
.720	$\pm .005$	.724				
1.396	$\pm .005 / .000$	1.396			H.G	
Ø1.305	$\pm .000 / -.005$	1.3025			Mich LPO2	
8-32 UNF-2B	G0 / N0 G0	G0				
.125	$\pm .005$	.1255			H.G	
1.73	$\pm .01$	1.723				
2.06	$\pm .01$	2.053				
.03 x 45°	$\pm .01 \times .5°$	.035 x 45°				
10-32 UNF-2B	G0 / N0 G0	G0				

Measured by:

P14-08-10

Checked by:

MIP

QC Inspector:

Date:

Date:

18/03/10

Date:

Engineering Approval:
(If necessary)

Date:

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

WORK ORDER NON-CONFORMANCE / UPDATE

Date: _____

Date: _____

Work Order update only ☐

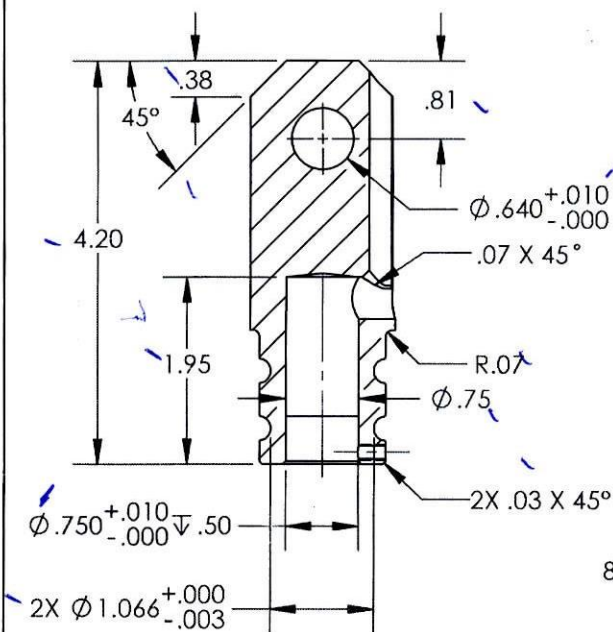
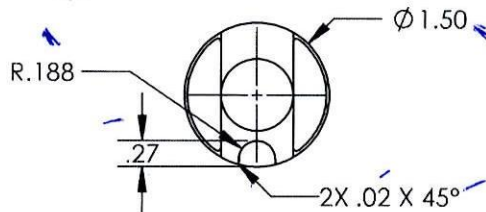
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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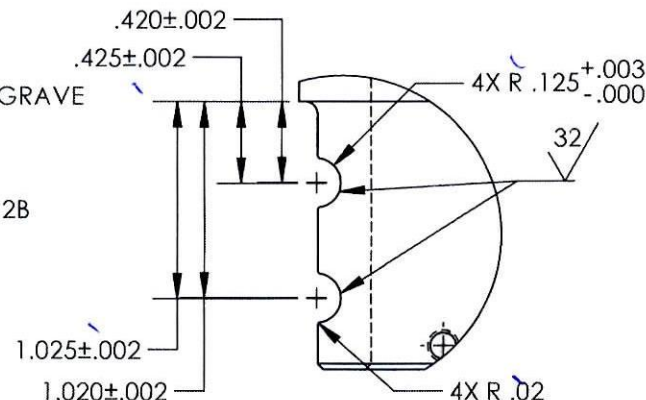
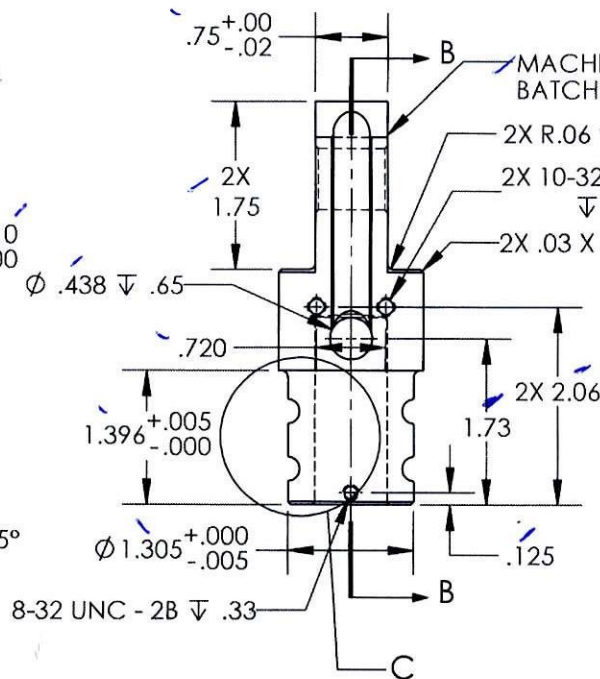


4725

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		AS DRAWN BY CANAM	8/24/2012		
8		ADDED MISSING .750 DIM, ADDED DEPTH .500 TO Ø.750	11/14/2012	JAG	
9		DELETED .02 X 45° FROM TOP, ADDED DRILL POINT DETAIL AND (1.99) DIM.	8/6/2013	RJC	GE
10	16-0084	REMOVED DIMS .981, .976, .381, .376, ADDED DIMS .420±.002, .425±.002, 1.020±.002, 1.025±.002, CH'D DIM WAS 1.75 IS 2X 1.75, WAS Ø1.066±.000/-0.003 IS 2X Ø1.066±.000/-0.003, WAS .750 IS .75±.00/-0.02, CH'D MATERIAL, WAS S.S. 17-4 PH. IS S.S. 17-4 H1150/H1075.	7/18/2016	SM	JAG
11	17-0027	CH'D DIM'S WAS .375 IS .38, WAS Ø.750 +.010/-0.000 ±.500 IS Ø.750 +.010/-0.000 ±.195, WAS R.069 IS R.07, WAS 2X .030 X 45° IS 2X .03 X 45°, WAS 2X 10-32 UNF -2B ±.500 IS 2X 10-32 UNF -2B ±.50, WAS 8-32 UNC -2B ±.328 IS 8-32 UNC -2B ±.33, WAS 4X R.015 IS 4X R.02, DELETED DIM'S 1.95, Ø.750, ADDED NOTE MACHINE ENGRAVE BATCH #.	2/1/2017	RJC	JAG
12	17-0146	CH'D DIM WAS Ø.750 +.010/-0.000 ±.195 IS Ø.750 +.010/-0.000 ±.50, DELETED DIM (1.99), ADDED DIM'S 1.95, Ø.75.	6/20/2017	RJC	JAG



SECTION B-B

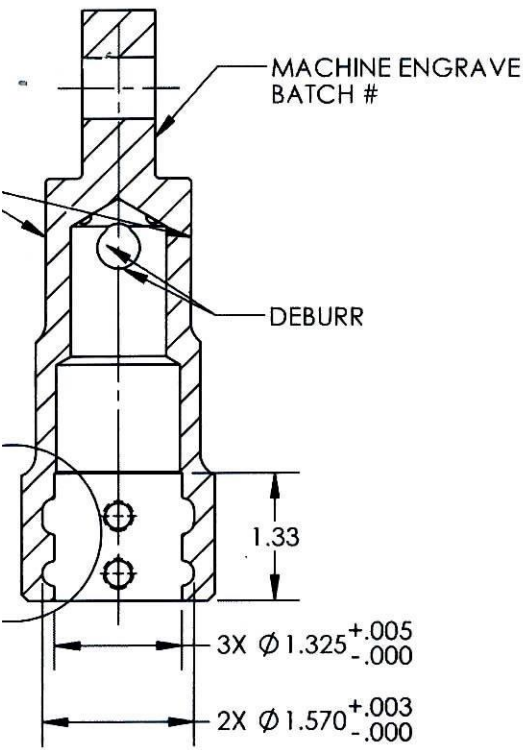


DETAIL C
SCALE 1 : 1

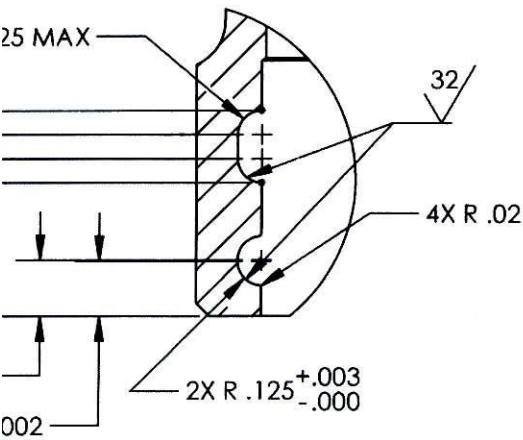
DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA3-200	REV 12
MAT'L S.S. 17-4, H1150/H1075 HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓	
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES Ø15 X 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 5/16/2006
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			SWA3-200	1	LOWER END	S.S. 17-4, H1150/H1075		

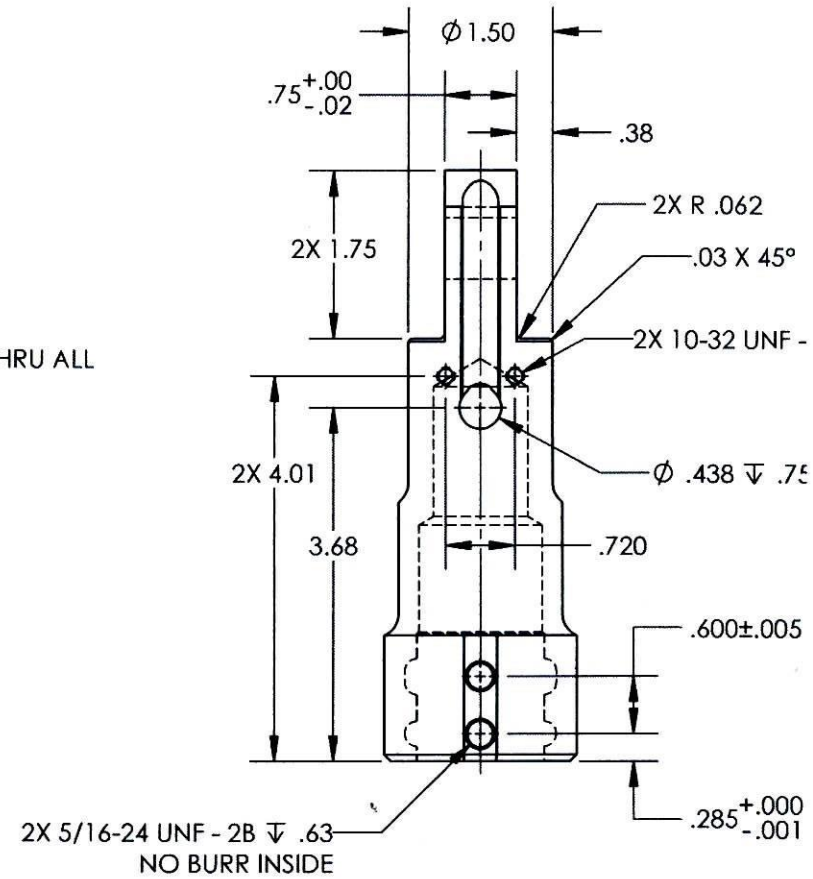
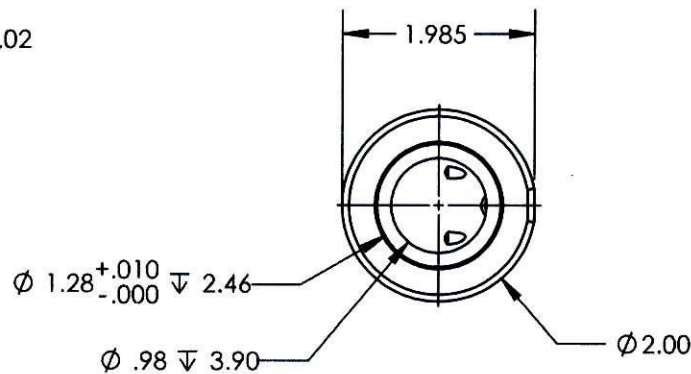
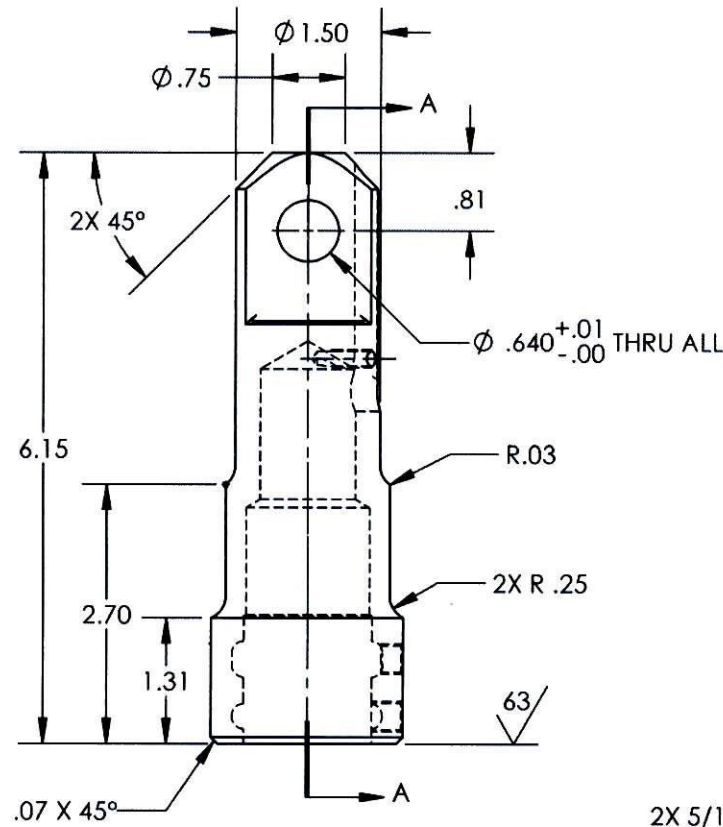
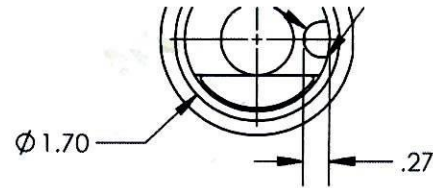
		Ø1.325 ^{+0.005} / _{-.000} , WAS Ø1.570 ^{+0.003} / _{-.000} IS 2X Ø1.570 ^{+0.003} / _{-.000} .
14	17-0036	CH'D DIM'S WAS 1.75 IS 2X 1.75, WAS 2X 5/16-24 UNF -2B ∇ .625 NO BURR INSIDE, WAS 4X R.015 IS 4X .02. ADDED NOTE MACHINE
15	17-0153	CH'D DIM WAS Ø1.00 ^{+0.010} / _{-.000} ∇ 3.90 IS Ø.98 ∇ 3.90.



SECTION A-A



DETAIL B
SCALE 1:1



TITLE	UPPE
DWG NO.	
MAT'L	S.S. 17-4, H11
HEAT TREAT	
FINISH	